

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028316**Date Inspected:** 30-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

12E PP116.5-BW3 (Interior)

This QA Inspector made random observations of ABF/JV qualified welder Guo Wu Chen #1556 performing the ongoing in process Shielded Metal Arc Welding (SMAW) in the 3G vertical position utilizing E7018-H4R electrodes. QC Inspector Salvador Merino verified the temperature and recorded the parameters as acceptable and within the requirements of ABF-WPS-D1.5-1040A-Revision 1. The welder was observed welding the height of the joint followed by grinding and blending of the work utilizing a small disc grinder. On a subsequent observation, this QA Inspector noted that the welding was performed in the vertical position utilizing the E7018-H4R low hydrogen electrodes. The 3.2mm electrodes were stored in electrically heated, thermostatically controlled oven after removal from the sealed containers. The exposure limits of the electrodes appeared to comply with the minimum storage oven temperature of 120 degrees Celsius as per the contract documents. The welding parameters and surface temperatures were verified by the QC inspector's utilizing a Fluke 337 clamp meter to measure the electrical welding parameters and Tempilstik Heat Indicators for verifying the preheat and inter-pass temperatures. At the time of the observation no issues were noted by the QA. On subsequent observations throughout the shift to monitor quality, it was noted that the work was in progress and appeared to be in general conformance with the contract documents.

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12E PP113-BW2 (Interior)

This QA Inspector at random intervals observed SMAW in the 3G vertical position performed by ABF/JV qualified welder Jose Torres on the beam web at 12E PP113-BW2 on the interior of the OBG. The welder was observed heating the joint prior to welding which this QA Inspector verified the minimum pre-heat temperature with a Tempilstik and the 3.2mm E7018-H4R electrodes were obtained from a baking oven which was maintained at 120° C. QC Inspector Salvador Merino was present to monitor the welding and the parameters for compliance with ABF-WPS-D1.5-1040A-Revision 1. On subsequent observations to monitor quality, the welder was observed cleaning the work between passes as QC measured the inter-pass temperatures. This QA Inspector noted no issues during welding and it was noted that the work was in progress and appeared to be in general conformance with the contract documents.

12E PP115.2-BW1 (Interior)

This QA Inspector randomly observed ABF/JV qualified welder Chris Bowles #9317 perform the SMAW process in the 3G vertical position on the beam web located at 12E PP115.2-BW1 on the interior of the OBG. QC Inspector Salvador Merino was observed monitoring the welding on the material the pre-heat and parameters as they pertain to ABF-WPS-D1.5-1040A-Revision 1. The welder was observed drawing 135 amperes with the 3.2mm E7018-H4R electrodes and was noted as cleaning the work between passes utilizing a small disc grinder. This QA Inspector noted that the work at this location is ongoing production work and no issues were noted at the time of the observations. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract specifications.

QA NDT (Interior)

This QA Inspector performed Magnetic Particle (MT) testing on the lifting lugs of the jacking frames located at W2. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.2.1. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

13E PP111.1 (interior)

This QA Inspector randomly observed the excavation operations of an Ultrasonic rejectable indication on the CJP joint at 12E PP111.1 on the interior of the OBG. This QA Inspector observed ABF/JV qualified welder Wai Kit Lai #2953 performing the CAG method to remove metal from the material. The welder was observed cleaning up the excavations utilizing a small disc grinder and a de-burring drill. Upon completion of the excavations, QC Inspector Salvador Merino performed a MT of the sites to determine soundness of the metal and observed no indications, QC then measured the dimensions of the excavation for length, width and depth. This QA Inspector recorded the dimensions of the excavations as:

Y=600mm: 90mm in length, 20mm wide and 11mm deep. y=1210mm; 9mm in length, 45mm wide and 8mm deep, y=1330mm; 100mm in length, 35mm wide and 10mm deep.

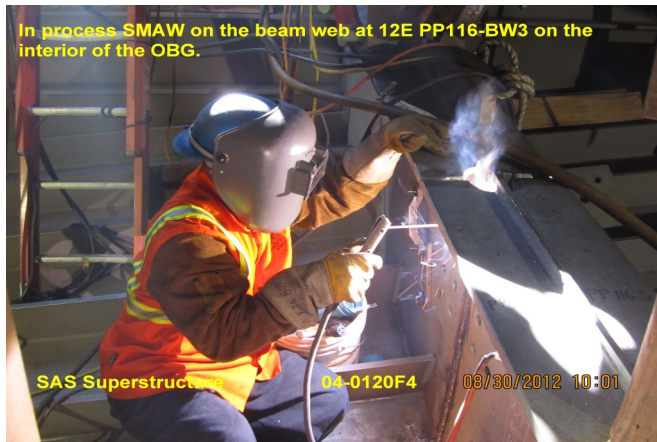
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Prior to welding, QC Inspector Salvador Merino was observed monitoring and measuring the pre-heat temperatures and parameters as they pertain to ABF-WPS-D1.5-1004-Repair-Revision 0. This QA Inspector made random observations of SMAW in the 3G vertical position and noted no issues concerning welding at this location and an RWR is pending. This QA Inspector made subsequent observations throughout the shift to monitor quality and it was noted that the E7018-H4R electrodes were stored properly in a sealed container after being opened and they were drawing amperage of 136. The welder was observed continuing the in process repair welding and this QA Inspector noted that no issues were present at this location. QC Inspector Salvador Merino was also present to monitor the welding and the parameters in the later stages of the shift. This QA Inspector noted that the work at this location was completed on this date and appeared to be in general conformance with the contract specifications.

Summary of Conversations:

Discussed welder locations and assignments with Quality Control Inspector Salvador Merino.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
